

Work Order ID 138546

November 02, 2015 11:05:39 AM

138546

Page 1

Item ID: D206-836-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 11/2/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

SH

Date:

20151102

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
GA202-2	A								
100	Document Control	0.00							
100									
DC	Memo	0.00							
Doc.Control -USB or Paperwork Photocopy bluefile and create labels as per PPP D206-836-011 CH001									
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

stock.

MLJ 15-11-03

*BAS
27
9-89*

*DAS
6
9-89*

2

NOV 05 2015

*BAS
27
9-89*

NOV 03 2015

*DAS
28
9-89*

*DAS
6
9-89*

2

NOV 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 138546***138546***

Page 2

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Item ID: D206-836-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 11/2/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 11/5/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-836-011
Location : FG1222 DAS
0
9.00
NOV 05 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS NOV 05 2015

MCS NOV 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence					
☐ OTHER : _____									

Picklist Print

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Page 1

Work Order ID: 138546

138546

Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 11/2/2015

Required Date: 11/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.05.28 NEW ISSUE DD VERF:JLM
REV:B 13.07.18 AS PER ECN13-561 DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4853-3 *D4853-3* Top Bracket (Replaces P/N G13013-5)		Manufactured	No				Each	29.0000				DAS 27 9-89	DAS 28 9-89
	DAS 6 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST519			29						
				109076			29						
D4854-3 *D4854-3* Lower Bracket (Replaces P/N G13013-6)		Manufactured	No				Each	30.0000				DAS 27 9-89	DAS 28 9-89
	DAS 6 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st526			30						
				104866			1						
				109081			29						
D4855-1 *D4855-1* Antenna Bracket (Replaces P/N G13013-3)		Manufactured	No				Each	7.0000					
	DAS 6 9-89			<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				st526			7						
				126143			1						
				128258			6						

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Picklist Print

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Work Order ID: 138546

138546

Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 11/2/2015

Required Date: 11/5/2015

Start Qty: 1.00

Required Qty: 1.00

D2732-030

Manufactured No

Each 210.0000

D2732-030

Rubber Cushion - 3"

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	86	
134608	32	
135594	46	
136784	8	
ST410	124	
136756	10	
136784	114	

DAS
27
9-89
DAS
28
9-89

AN4-16A

Purchased No

Each 188.0000

AN4-16A

Bolt

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	5	
121541	5	
ST325A	182	
M133011	40	
M133064	25	
M133483	117	
ST343	1	
M132317	1	

DAS
27
9-89
DAS
28
9-89

AN4-11A

Purchased No

Each 134.0000

AN4-11A

BOLT

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FG	20	
120731	20	
ST325A	114	
M128362	14	
M133234	100	

DAS
27
9-89
DAS
28
9-89

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Shop Packet Print

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Picklist Print

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Work Order ID: 138546

138546

Parent Item: D206-836-011

D206-836-011

Parent Item Name: Crosstube Antenna Mount 206 A/B AFT & 206A/B/L FWD

Start Date: 11/2/2015

Required Date: 11/5/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

Each

587.0000

NAS1149D0432J

WASHER

**

DAS

27

9-89

DAS

28

9-89

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

230

m131026

230

ST269

357

m131026

357

Each

2,444.000

**

DAS

27

9-89

DAS

28

9-89

MS2104214

Purchased

No

MS2104214

Locknut

Location

Loc Qty

Loc Code

CCK004

2000

m133363

2000

FP001

2

m124231

2

GA

67

m127813

67

ST260a

138

m130799

56

m131803

6

m132262

76

ST305

237

m128300

8

m130388

7

m130922

97

m132123

56

m133316

69

DAS

6

9-89

NOV 03 2015

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -111	Part Number	Description
X					D206-836-011	CROSSTUBE ANTENNA MOUNT KIT 206A/B AND 206L FWD (P162-206)
	X				D206-836-013	CROSSTUBE ANTENNA MOUNT KIT 206L AFT (P162-206L)
		X			D407-836-015	CROSSTUBE ANTENNA MOUNT KIT 407 FWD (P162-407F)
			X		D407-836-017	CROSSTUBE ANTENNA MOUNT KIT 407 AFT (P162-407A)
				X	D206-836-111	CROSSTUBE ANTENNA MOUNT KIT UNIVERSAL (P162-U)
			1	1	D4853-1	TOP BRACKET (REPLACES P/N G13013-1)
1				1	D4853-3	TOP BRACKET (REPLACES P/N G13013-5)
		1		1	D4853-5	TOP BRACKET (REPLACES P/N G13013-7)
	1			1	D4853-7	TOP BRACKET (REPLACES P/N G13013-9)
			1	1	D4854-1	LOWER BRACKET (REPLACES P/N G13013-2)
				1	D4854-3	LOWER BRACKET (REPLACES P/N G13013-6)
		1		1	D4854-5	LOWER BRACKET (REPLACES P/N G13013-8)
	1			1	D4854-7	LOWER BRACKET (REPLACES P/N G13013-10)
1	1	1	1	1	D4855-1	ANTENNA BRACKET (REPLACES P/N G13013-3)
2	2	2	2	2	D2732-030	RUBBER CUSHION (REPLACES P/N G13013-4)
2	2	2	2	2	AN4-16A	BOLT
2	2	2	2	2	AN4-11A	BOLT
8	8	8	8	8	NAS1149D0432J	WASHER
4	4	4	4	4	MS21042L4	LOCKNUT